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D4881-042

Job Sheet 180538



Part No: D4881-042

Job Qty: 2 ea

Part Name: 206A/B AFT Leg Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/9/18

Job Tracking No:

Due Date: 8/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 3,4 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-4		JUL 12 2018
110	Small Fab	2 pcs	8/7/18	8/7/18	0.00	1.56	Small Fab-8		JUL 12 2018
120	QC	2 pcs	8/7/18	8/7/18	0.00	0.00	QC5		SmB
130	Small Fab	2 pcs	8/7/18	8/7/18	0.00	1.56	Small Fab-8		15-08-03
140	QC	2 pcs	8/7/18	8/7/18	0.00	0.00	QC5		SmB
180	Packaging	2 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-2		15-08-07
190	QC21-SA	2 Ea	8/7/18	8/7/18	0.00	0.00	QC21		AUG 08 2018

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND D4885-3. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9974
AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER
DWG USE DT9974 A/R BATCH: 138848 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG
QSI 44 6.8

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	2 Ea (1 ea)	90-Start up Operation	F162833
D4885-2	End Fitting	2 Ea (1 ea)	90-Start up Operation	F124006
D4885-3	End Fitting	2 Ea (1 ea)	90-Start up Operation	5003356
HL32PB5-12	Hi-Lok Pin	8 Ea (4 ea)	90-Start up Operation	5009248
HL86-5	Hi-Lok Collar	8 pcs (4 ea)	90-Start up Operation	F4109022

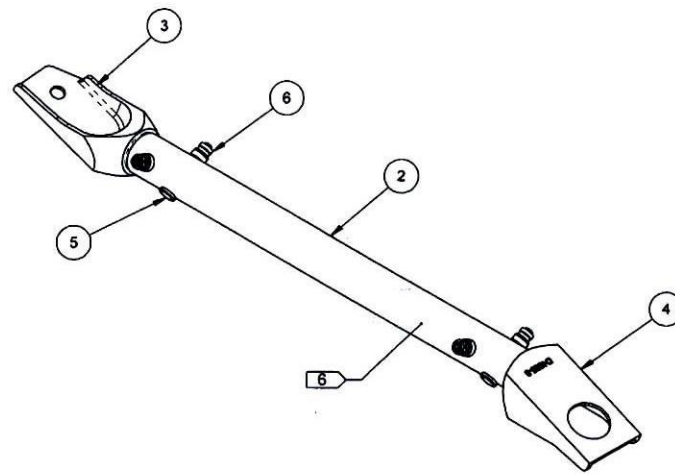
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4881-1	2	0	0
	D4885-2	2	4	0
	D4885-3	2	6	0
	HL32PB5-12	8	32	0
	HL86-5	8	95	0

Part Specifications

Specifications could not be found.

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4881-041	AFT LEG ASSEMBLY, LH
2	1	D4881-1	STRUT
3	1	D4885-1	END FITTING
4	1	D4885-3	END FITTING
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4881-041 AFT LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-103-017)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.77 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 ($\varnothing 0.1610$) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASED
2014-07-07

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B2-2, B1-4, B2-4)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4881	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED